



Dart Aerospace Ltd.
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RBE350A93-3400-00

Job Sheet 170574



Part No: RBE350A93-3400-00

Job Qty: 6 ea

Part Name: Drive Shaft Thimble



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBE350A93-3400-00 REV 3 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	6 pcs	2/27/18	2/27/18	0.08	0.60	Small Fab-9		MCC
110	QC	6 pcs	2/27/18	2/27/18	0.00	0.00	QC5		
130	Packaging	6 pcs	2/27/18	2/27/18	0.00	0.00	Packaging3-2		
140	QC21-FG	6 Ea	2/27/18	2/27/18	0.00	0.00	QC21		MCC 18/02/18

Part Op 100 - Assemble as per DWG

Descriptions: 130 - Identify and Stock

DAS
21
3-ec

MAR 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
4491K61	Dowel Pin Ø6mm x 40mm	6 Ea (1 ea)	90-Start up Operation	
RBE350A93-3400-00-1	Guide	6 Ea (1 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:26 AM Dart.lajeunesse.marie

PNL 3-28



Container No: S055919



Part: RBE350A93-3400-00

Job No: 170574

Serial No/Batch: S055919

Revision: 3

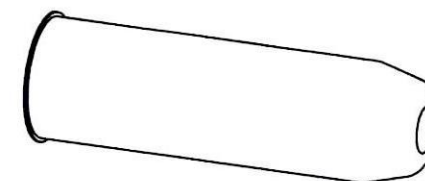
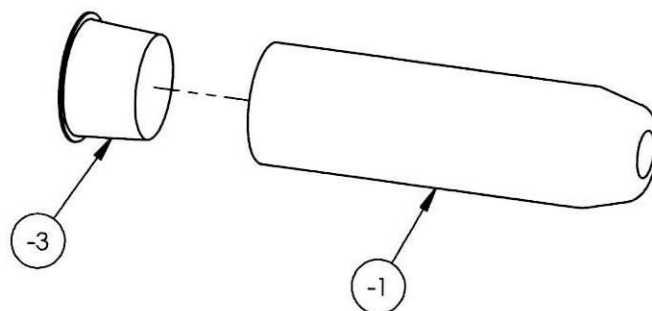
Inspector:

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Date: 03/28/16

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED FROM HELI PRODUCTS TOOLS.	10/15/2009	WP	DW
2		CH'D THIMBLE TO GUIDE AND MATERIAL FROM 4140 Q&T, ADDED BLEND NOTE PER D.W.	9/15/2011	RJC	DW
2A		CH'D T/N WAS RBEA93-3400-00 IS RBE350A93-3400-00.	11/6/2013	RJC	RW
3	17-0172	UPDATED TO NEW STANDARD. ADDED DASH NUMBERS. -1 CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, & "MADE IN USA" TO FIT IS ENGRAVE T/N. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D MAT'L FROM 4140 TO 4140/4142. DELETED DIMS (.630), 75°. ADDED DIMS 3.718±.050, 15°. CH'D DIM WAS R.200 IS R.20.	7/13/2017	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 17054 M-J
1801-18

DART AEROSPACE	
TITLE DRIVESHAFT THIMBLE	
DWG NO. RBE350A93-3400-00	REV 3
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/21/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EUROCOPTER 350/355
SCALE 1:2	DATE 10/15/2009
SHEET 1 OF 2	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	GUIDE	4140/4142		2
		B/O	-3	1	PUSH IN TAPERED ROUND CAP	PLASTIC	Ø1.298 I.D. X Ø1.173 I.D. X 13/16 (MCMASTER-CARR #4491K61)	1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :			